

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-021263**Date Inspected:** 02-Jul-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Wu Zhi Cheng**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Segment Assembly**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Ramesh Gade, was present during the times noted above for observations relative to the work being performed.

This QA Inspector observed the following work in progress:

OBG Segment 9AW-9BW

Shielded Metal Arc Welding (SMAW) in the 4G position of Cross Beam side Edge Panel to side Panel, weld joint 9AW-CA056-001 & 9BW-SEG051A-046. The welder is identified as 068097. ZPMC Quality Control (QC) is identified as Wang Zhu. The welding variables recorded by QC appeared to comply with WPS-B-P-2214-TC-U4b-FCM-1. See attached photograph Pic\_001

OBG Segment 9AW

During in process visual inspection of 9AW, This QA Inspector observed ABF Quality Assurance (QA) personnel Mr. Ding performing Ultrasonic Testing (UT) on Cross Beam side SP to BP weld repaired area. See attached photograph Pic\_002

OBG Segment 9BE-9CE

Shielded Metal Arc Welding (SMAW) in the 4G position of Cross Beam side Edge Panel to side Panel, weld joint

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9BE-SEG052A-028 & 9CE-CA063-001. The welder is identified as 220067. ZPMC Quality Control (QC) is identified as Wu Zhi Cheng. The welding variables recorded by QC appeared to comply with WPS-B-P-2214-TC-U4b-FCM-1.

OBG Segment 9BE-9CE

Shielded Metal Arc Welding (SMAW) in the 4G position of Cross Beam side Bottom Panel to side Panel, weld joint 9BE-SEG052A-021. The welder is identified as 054467. ZPMC Quality Control (QC) is identified as Wu Zhi Cheng. The welding variables recorded by QC appeared to comply with WPS-B-P-2214-B-U2-FCM-1.

OBG Segment 9BE-9CE

Flux Core Arc Welding (FCAW) in the 3G position of Bile Path side Bottom 'T' Rib, weld joint BP125-030. The welder is identified as 220066. ZPMC Quality Control (QC) is identified as Anqing Xiang. The welding variables recorded by QC appeared to comply with B-T-2233-B-U2-F.

OBG Segment 9BE-9CE

Flux Core Arc Welding (FCAW) in the 1G position of Bile Path side Bottom Panel to Edge panel, weld joint SEG054A. The welder is identified as 220066. ZPMC Quality Control (QC) is identified as Anqing Xiang. The welding variables recorded by QC appeared to comply with WPS-B-T-2231T-1.



### Summary of Conversations:

No relevant conversations reported on this date.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang (+86)15000 42 2372, who represents the Office of Structural Materials for your project.

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**Inspected By:** Gade,Ramesh

Quality Assurance Inspector

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**Reviewed By:** McClendon, Timothy

QA Reviewer